

Date: Monday, 04/02/2008 3:08:27 PM
 User: Dominique Dube

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 STEP ASSEMBLY (3)
 Job Number : 37017-2
 Estimate Number : 11798
 P.O. Number :
 This Issue : 04/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 25/01/2008 Type : LARGE FAB ASSY
 Previous Run : 33924
 Written By :
 Checked & Approved By :
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Part Number : D206628034
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision :
 Material :
 Due Date : 10/03/2008 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-034 CHG 002

2.0 37017A FLOAT STEP ASSEMBLY RH (206/407)



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2842-042 B 37017A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

UPDATED AS PER ECN 1118, D206-268-034 CHG NUM. 003

4.0 D27313 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-3 Mounting Lug

133995

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1

Arm 137243

8/3/14

50

(3x)

Date: Monday, 04/02/2008 3:08:28 PM
User: Dominique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37017

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2844-3

Arm 1534876

54

7.0

D2732030

Rubber Cushion



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part #

Description

Batch

8 D2732-030

RUBBER CUSHION

1534717

54

8.0

D3394041

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-041

LUG ASSY

1530997

54

9.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C14A

Bolt

1107087

54

10.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

1105589

54

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

1103915

8/3/17 54

(3x)

Date: Friday, 1/25/2008 10:59:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37017

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M106302

SP

13.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L

Washer

M106785

SP

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

M101428

M105408

SP

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4

Nut (or MS21042-4)

M101101

SP

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3

Washer

M106431

8/3/08

SP

3X

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0803-10

3

08/03/11

43

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 01/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:59:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37017

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-034

Location: _____

PPP Rev: _____

D

8/3/11

50

(3)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

Doe 10/3/12

Job Completion



mi 2008/3/11

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37017A
Estimate Number : 11775
P.O. Number :
This Issue : 1/25/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : LARGE FAB ASSY
Previous Run : 33922A
Written By :
Checked & Approved By :
Comment : Est Rev. D As Per Ecn 766 06-01-06 JLM

Drawing Name : FLOAT STEP ASSEMBLY RH (206/407)
Part Number : D2842042
Drawing Number : D2842 REV B
Project Number :
Drawing Revision : B
Material :
Due Date : 3/10/2008 Qty: 4 Um: Each

(3)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion 1335618

Check Material for any Dents or Defects

SAW 08/02/25 (3)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

3-Deburr and bevel ends for welding

SAW 08/02/25 (4)

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch

2 D2734 End Cap 336520

SAW 08-02-26 4

4.0 D34591 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

plate

Batch: 34429

SAW 08-02-26 4

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 37017A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
plate
Batch: 34430

Handwritten: 08-02-26 4

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg D2842
A/R AL Rod Batch: M105058
M106762
2-Grind end cap weld flush

Handwritten: 08-02-26 3

7.0 ~~DO NOT USE~~ WELD INSPECTION



Comment: WELD INSPECTION

Handwritten: acs 5081313 08

Handwritten: acy 08-03-03 3

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 08-03-04

Handwritten: 13

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-03-04 3

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
A/R AL Rod Batch: M106762
M105058
2-Grind end cap weld flush.

Handwritten: 08-03-04 3
SAD 08/03/06 3

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 37017A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FD 08-03-06 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/06 (x3)

13.0

POWDER COATING

POWDER COATING



M107005



(3X)

Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Touch-up Alodine M.H. 08/03/06 (3X) M.H. 08/03/06

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/03/07 (3)

15.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3 NAS1329C3KB130

Insert

M106951

FD

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 MS27039C1-07

Screw

M106785

FD

17.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3L

WASHER

M106516

FD 08/03/10 (3)

M106516

Date: Friday, 1/25/2008 11:28:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 37017A

Part Number: D2842042

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10L

WASHER

9
m/07242

FL

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: m/06894

>

FL 08/03/10

(3)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 08-03-10

(3)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 37017 PC 8/3/11 (3)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



FL 08/03/12

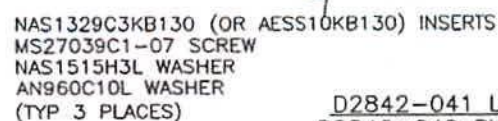
(3)

Job Completion



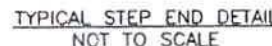
mi 2008/3/11 (3)

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.		REV. B
CHECKED		APPROVED		DRAWING NO.	D2842	SHEET 1 OF 1
DATE	05.09.23			TITLE	206L/407 FLOAT STEP ASSEMBLY	
A	98.10.13			NEW ISSUE	RE-DESIGN, ADD D3459-1/-3	
B	05.09.23			NTS		



NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AFSS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C 10L	WASHER



- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14

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